

User

Tuesday, 4/29/2008 8:18:22 AM

David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT PLATE LH
 Job Number : 38860
 Estimate Number : 13283
 P.O. Number :
 This Issue : 4/29/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : SMALL / MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-04-25 new issue DD verified by:EC

Part Number : D36973
 Drawing Number : D3697 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 5/6/2008 Qty: 1 Um: Each

R+A
08-04-30
(Pb2)
Last page

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



PRELIMINARY ISSUE

Seq. # Machine Or Operation: Description:

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.4797 sf(s)/Unit Total: 0.4797 sf(s)
 6061T6 aluminium sheet .050" thick
 (M6061T6S050)
 Batch: *104186 IB 8-4-30*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3697
 Dwg Rev: *A* *IB 8-4-30*
 Prog Rev: *A*
 grain direction along 3.56"
 2- Deburr if necessary *IB 8-4-30*

①

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE
IB 8-4-30

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK
08/04/30

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Bend as per Dwg D3697
IB 08/05/07
08-05-01 ①

5.1 counter sink holes as per dwg D3697 FF 08-05-01 ①

5.2 QCS *08/05/08* ①

Date: Tuesday, 4/29/2008 8:18:22 AM
User: David Duval

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE LH

Job Number: 38860

Part Number: D36973

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

5/2/08/08.05.06

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

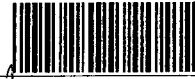
Location: _____

give to David Duval

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.13 RORRYPE

Job Completion



*Charge to
w/o # 00235*

08.05.09

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-776-011

Job #: 00235

Date: 25-Apr-08

Product Name: B412 Glareshield

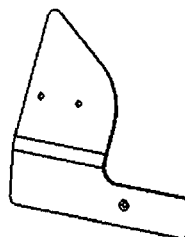
Requested By: MP for RF

Design Manager Approval: 

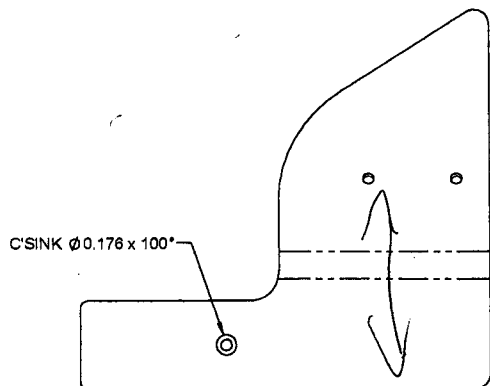
Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3697-1	Tube	31/03/2008	y	09-May-08		
1	D3797-1	Ground Plate	31/03/2008	y	09-May-08		
1	D3697-3	Support Plate LH	31/03/2008	y	09-May-08		
1	D3697-4	Support Plate RH	31/03/2008	y	09-May-08		
1	D3698-1	Support Angle	31/03/2008	y	09-May-08		
1	D3690-1	Glareshield	31/03/2008	y	09-May-08		
1	D3697-041	Tube assy	31/03/2008	y	09-May-08		
1	D3699-041	Support Assy	31/03/2008	y	09-May-08		
1	D3699-042	Support Assy	31/03/2008	y	09-May-08		
1	D3690-041	Glareshield Assy	31/03/2008	y	09-May-08		



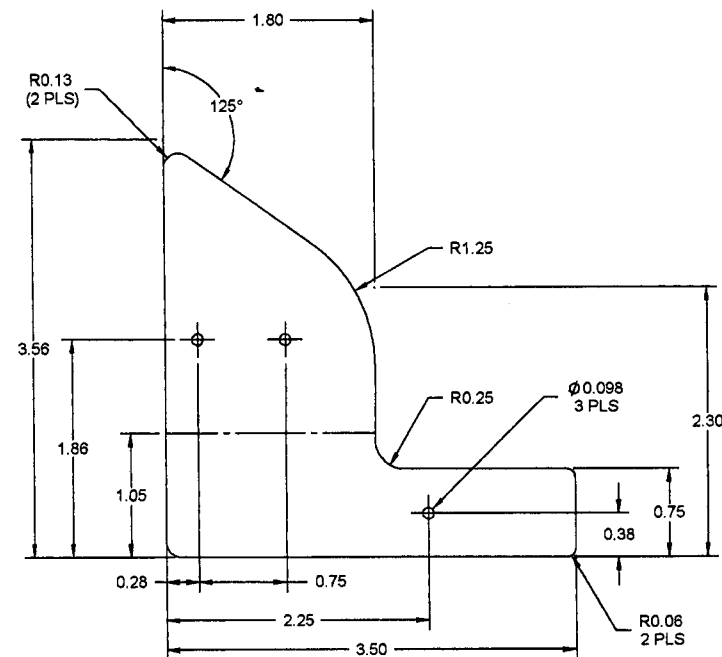
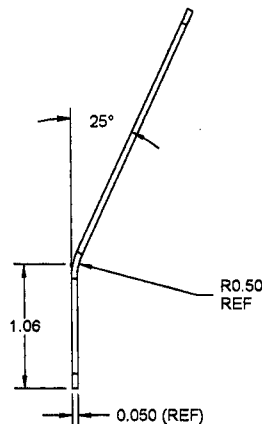
D3697-3 SUPPORT PLATE (LH SHOWN)



D3697-4 SUPPORT PLATE (RH SHOWN)



**D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
(MAKE FROM D3697-3F FLAT PATTERN)**



D3697-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

PRELIMINARY ISSUE

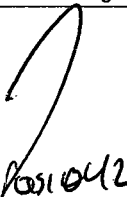



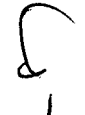
08.04.25 *MP*

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3697	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		TUBE ASSEMBLY	1:1
DATE	08.03.31	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OF COMB OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/08	#20	welded in wrong orientation Didn't pay attention to the Final Draw.	 104186	Scrap and Destroy and replace Qty <u>1</u> BA <u>104186</u>	 08/05/08	 08/05/08	 104186	 08/05/08

NOTE: Date & initial all entries

Receiving Report

Date: 07/04/20

Batch No: 17104186

Supplier: Magna

Dart P/O: 3581

Packing Slip: Yes / No /
 Invoice: Yes / No /
 Receipt: Cash / Cr /

Release Note Attached: Yes / No / N/A /
 Waybill Attached: Yes / No / N/A /
 Shipment Complete: Yes / No / N/A /
 QC6 Inspection / N/A /
 Work Order / N/A /

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	6061-T6 Alum	40	0	0	40	
	Flat 3/4x3					

Initials of receiver (if shipment OK) Level 12 JP

Production/Admin:

Date

Received/Costing

Initial

07/04/20
R/P 9401-4417
CS

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Sub-Total
 G.S.T.

468.00
 28.00

TOTAL →

496.00

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ D'U.
 LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
 AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
 ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
 THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
 BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTRÉAL.

BB/31/85 16:58:41

Fax Server ->

426 213 9587 Fax Server

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Novelis Deutschland GmbH, Werk Neustadt
 Novelis Automotive, Painted & Specialties
 Gießerei Straß 1 Postfach 1345
 D-85635 Neustadt am Main
 Tel.: (0242) 49 77-0
 Fax: (0242) 49 77-20
 www.novelis.com

Novelis

452916/452916/1
 452917/278/279

Abnahmeprüfung
 Inspection Certificate
 Certificat de Réception
 Nr./No. 6135222-9

Standard

ANSI-Q1-A-250/11 (1997)

Article Nr. Art. No.	Material Mat.	Norm Norm	Größe Size	Material Mat.	Norm Norm	Größe Size
0000080883		6061	15	6061		15
Größe Size	21.198	kg				
Material Mat.						

Chemische Zusammensetzung in Gewichtsprozent
 Chemical composition in percentage by weight
 Composition chimique en pourcentage de poids

Chemische Zusammensetzung Chemical composition	Si	Mn	P	S	Fe	Al	Cu	Mg	Zn	Co	Ni	Cr	Mo	Other
100 089436	0,52	0,24	0,25	0,08	0,85	0,09	0,01	0,01	0,02					
100 089437	0,52	0,24	0,25	0,08	0,85	0,09	0,01	0,01	0,02					
100 089438	0,52	0,24	0,25	0,08	0,85	0,09	0,01	0,01	0,02					
100 089439	0,52	0,24	0,25	0,08	0,85	0,09	0,01	0,01	0,02					
100 089440	0,52	0,24	0,25	0,08	0,85	0,09	0,01	0,01	0,02					

Mechanische Eigenschaften
 Mechanical properties
 Caractéristiques mécaniques

Temp. Temp.	Stärke Thickness	Bruchdehnung Elongation	Bruchlast Tensile strength	Bruchenergie Toughness	Bruchzeit Time to failure	Bruchmodus Failure mode	Bruchort Failure location
10	3903906	8222500001	1,48 * 121,4 * 387,49 m	281	320	11	
	3903906	8222500002	1,48 * 121,4 * 387,49 m	281	320	11	
	3903906	8222500003	1,48 * 121,4 * 387,49 m	281	320	11	
	3903906	8222500004	1,48 * 121,4 * 387,49 m	281	320	11	
20	211637	8192100005	1,48 * 121,4 * 387,49 m	281	320	11	
	211637	8222700004	1,48 * 121,4 * 387,49 m	281	320	11	
	211637	8222700005	1,48 * 121,4 * 387,49 m	281	320	11	
40	211637	8222700006	1,48 * 121,4 * 387,49 m	281	320	11	
	211637	8222700007	1,48 * 121,4 * 387,49 m	281	320	11	
	211637	8222700008	1,48 * 121,4 * 387,49 m	281	320	11	
60	3903906	8222400001	1,48 * 121,4 * 387,49 m	281	320	11	
	3903906	8222400002	1,48 * 121,4 * 387,49 m	281	320	11	
	3903906	8222400003	1,48 * 121,4 * 387,49 m	281	320	11	
	3903906	8222400004	1,48 * 121,4 * 387,49 m	281	320	11	
	3903906	8222400005	1,48 * 121,4 * 387,49 m	281	320	11	

This certificate has been made out by ERP and shall be kept as long as required.

Neustadt, 9.08.05

Zuständig (responsible): 120472, 120473, 120474, 120475, 120476, 120477, 120478, 120479, 120480, 120481, 120482, 120483, 120484, 120485, 120486, 120487, 120488, 120489, 120490, 120491, 120492, 120493, 120494, 120495, 120496, 120497, 120498, 120499, 120500, 120501, 120502, 120503, 120504, 120505, 120506, 120507, 120508, 120509, 120510, 120511, 120512, 120513, 120514, 120515, 120516, 120517, 120518, 120519, 120520, 120521, 120522, 120523, 120524, 120525, 120526, 120527, 120528, 120529, 120530, 120531, 120532, 120533, 120534, 120535, 120536, 120537, 120538, 120539, 120540, 120541, 120542, 120543, 120544, 120545, 120546, 120547, 120548, 120549, 120550, 120551, 120552, 120553, 120554, 120555, 120556, 120557, 120558, 120559, 120560, 120561, 120562, 120563, 120564, 120565, 120566, 120567, 120568, 120569, 120570, 120571, 120572, 120573, 120574, 120575, 120576, 120577, 120578, 120579, 120580, 120581, 120582, 120583, 120584, 120585, 120586, 120587, 120588, 120589, 120590, 120591, 120592, 120593, 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